

Work Order ID 60416

July 7, 2010 11:13:03 AM

Page 1

Item ID: D350-588-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10 Start Qty: 4.00

Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: CZ Date: 10/7/12 Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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N/A	Rev N/A
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0.00

100



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

8/10/12

0.00

110



Pick Kit

0.00

Packaging

Memo

Packaging

10-7-12 sf (40)

0.00

120



QC4- 100% Inspect kits for completeness

0.00

QC

Memo

Quality Control

8/10/12

(X40)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60416

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Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>25</u>								
	PPP Rev: <u>C</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-7-12 (4) SP

10-7-13

10-7-12 (4)

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Picklist Print

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Work Order ID: 60416

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

68.0000

12

18



Screw

Location

Loc Qty

Loc Code

ST328

68

113064

17

113749

1

114056

50

AN526C832R8

Purchased

No

120

Each

228.0000

18

32



Screw

Location

Loc Qty

Loc Code

ST327

228

113595

28

114615

100

114718

100

AN526C832R9

Purchased

No

120

Each

220.0000

18

32



Screw

Location

Loc Qty

Loc Code

ST327

220

114341

200

114405

20

AN960JD10

NAS1149D0363J

Purchased

No

120

Each

0.0000



Washer

16

1144884

5

114492

10-7-12

11/15/07

W/O:			WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

AN960JD8 - NAS1149DN832 Purchased No

120

Each

0.0000

24

196



Washer

D2143

Manufactured No

120

Each

21.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST198

21

55323

21

D2144

Manufactured No

120

Each

46.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST198

46

55179

46

D2150

Manufactured No

120

Each

42.0000

2

8



Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST007

42

55178

42

D2151

Manufactured No

120

Each

27.0000

2

8



Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST007

27

55319

27

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Shop Packet Print

Page 2

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

D2153 Manufactured No 120 Each 42.0000



Door Prop



4

10-7-10 SP

Location

Loc Qty

Loc Code

ST272

42

55324

6

59818

36

Y

D2154 Manufactured No 120 Each 14.0000



Stud Bracket



1 4

10-7-10 SP

Location

Loc Qty

Loc Code

ST007

14

55325

14

Y

D2237 Manufactured No 120 Each 55.0000



Striker Plate



2 8

10-7-10 SP

Location

Loc Qty

Loc Code

ST009

55

58181

55

8

D2461 Manufactured No 120 f 257.5242 7.25



Neoprene "D" Seal



30.52632

10-7-10 SP (42)

Location

Loc Qty

Loc Code

ST402

257.5242105

39782

6.5

55054

251.024211

cut 1 X 87.00"

7 measured
50/10/12
+4

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

D2463

Manufactured No

120 f

315.0018 7.25 30.52632



Seal

10-7-12 SP

S+Y

Location

Loc Qty

Loc Code

ST404 315.0018105
43841 3
50075 11.3536
55561 300.648211

cut 1 X 87.00"

D2583

Manufactured No

120 Each

20.0000



Latch Bracket

10-7-12 SP

S+Y

Location

Loc Qty

Loc Code

ST018 2
56527 2
ST117 18
59140 18

D2585

Manufactured No

120 Each

89.0000



Mounting Channel

10-7-12 SP

S+Y

Location

Loc Qty

Loc Code

ST019 89
56524 1
59118 62
59873 26

D2586

Manufactured No

120 Each

74.0000



Door Latch

10-7-12 SP (412)

S+Y

Location

Loc Qty

Loc Code

ST006 74
57917 74

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Page 4

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Work Order ID: 60416

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

D2587

Manufactured No

120

Each

36.0000



Door Slug, 350 Hinge



4

10.7.12.5

Location

Loc Qty

Loc Code

ST019

36

56555

36

120

Each

210.0000

D2589

Manufactured No



Keys, Key Chain, 350 Hinge



4

10.7.12.5

Location

Loc Qty

Loc Code

ST019

210

58194

210

120

Each

8.0000

D2690-17

Manufactured No



Cable



4

10.7.12.5

Location

Loc Qty

Loc Code

ST021

8

58212

8

120

Each

43.0000

D2857-1

Manufactured No



Hinge Bracket



4

10.7.12.5

4

Location

Loc Qty

Loc Code

ST026

43

56529

19

57924

24

4

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

D2857-2

Manufactured No

120

Each

53.0000



Hinge Bracket

Location

Loc Qty

Loc Code

ST027

53

55020

9

56530

20

57925

24

10.7.12sf

D2858-1

Manufactured No

120

Each

26.0000



Hinge Bracket

Location

Loc Qty

Loc Code

ST027

26

55062

5

56423

21

10.7.12sf

D2858-2

Manufactured No

120

Each

18.0000



Hinge Bracket

Location

Loc Qty

Loc Code

ST027

18

56048

18

10.7.12sf

FG-778150-550-ROL

Purchased No

120

sf

2,210.000



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

ST404

2210

108932

30

111166

405

113905

1775

10.7.12sf (40)

1- cut 1 square ft of glass cloth

July 7, 2010 11:13:02 AM

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

MS20426AD3-4

Purchased

No

120

Each

6,596.000

12

48



RIVET



10-7-12 SF

Location

Loc Qty

Loc Code

ST316

6596

104374

2596

110398

4000

48

MS20470AD4-5

Purchased

No

120

Each

1,507.000

18

72



Rivet, Universal Head



10-7-12 SF

Location

Loc Qty

Loc Code

ST309

1442

114761

1442

ST319

65

111916

65

72

MS21042L08

Purchased

No

120

Each

367.0000

18

72



Nut



10-7-12 SF

Location

Loc Qty

Loc Code

ST300

367

114330

167

115016

200

72

MS21042L3

Purchased

No

120

Each

2,835.000

4

16



Nut



10-7-12 SF (412)

Location

Loc Qty

Loc Code

ST300

2835

114523

353

114718

482

114784

2000

16

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Page 8 18

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Parent Item Name: Aft Door Fwd Hinge Modification



Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 4.00

Required Qty: 4.00

MS27039-08-11

Purchased

No

120

Each

77.0000

2

.8

Screw



10-7-12

SP

Location

Loc Qty

Loc Code

ST288

50

114382

50

ST290

27

113749

27

120

Each

121.0000

2

.8

MS27039-1-15

Purchased

No

Screw



8

8

10-7-12

4x

Location

Loc Qty

Loc Code

ST292

121

114056

21

114718

100

8

July 7, 2010 11:13:02 AM

Shop Packet Print

Page 8

W/O:			WORK ORDER CHANGES					
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NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

W/O:			WORK ORDER CHANGES					
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Required Date: 7/14/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: CY Date: 10/7/7 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

N/A Rev N/A

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

0.00

110



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

REFERENCE ONLY

CY 10/7/8